

Date: Thursday, 12/10/2006 11:45:19 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL MOUNT ANGLE
Job Number : 28923	
Estimate Number : 10780	
P.O. Number : N/A	Part Number : D32083
This Issue : 12/10/2006 S.O. No. : N/A	Drawing Number : D3208 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 28923	Material : N/A
Written By : _____	Due Date : 28/10/2006 Qty: 8 Um: Each
Checked & Approved By : _____	
Comment : Est: B04.05.25 Material changed for Step 4KJ/JLM Est Rev:C Now on Waterjet 06-10-12 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.0692 sf(s)/Unit Total : 0.5536 sf(s)

6061-T6 .063 Sheet

Material: 6061-T6 (QQ-A-250/11) 0.063" thick

(M6061T6S.063)

Batch: m18556 ml 06 10 12

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3208

Dwg Rev: A1

Prog Rev: A1

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

Date: Thursday, 12/10/2006 11:45:19 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL MOUNT ANGLE

Job Number: 28923

Part Number: D32083

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr D3208-3

Form D3208-3 as per Dwg D3208

Polish any marks on part within 01. of Dwg D3208

ml 06/10/16

SB 06/10/19

(8)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 10.20 (8)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

06/10/25 x8

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

06/10/26 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Sty 15 06/10/26 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/26 (8)

Job Completion



u 06/10/26

Date: Wednesday, 10/11/2006 11:12:18 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PEDAL MOUNT ANGLE
Job Number	: 28923		
Estimate Number	: 10780		
P.O. Number	:	Part Number	: D32083
This Issue	: 10/11/2006	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3208 REV A1
First Issue	: 11	Project Number	: N/A
Previous Run	: 28643	Drawing Revision	: A1
	Type : MACHINED PARTS	Material	:
Written By	: <u> </u>	Due Date	: 10/28/2006
Checked & Approved By	: <u> </u>	Qty:	8
Comment	: Est: B04.05.25 Material changed for Step 4KJ/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.0692 sf(s)/Unit Total : 0.5536 sf(s)
 6061-T6 .063 Sheet
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick
 (M6061T6S.063)
 Batch:

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
 Cut blank: 1.651" x 5.250" grain along 1.651"
 Identify for D3208-3

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Drill and Fillet D3208-3 corner as per Dwg D3208
 Identify as D3208-3

4.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr D3208-3
 Form D3208-3 as per Dwg D3208
 Polish any marks on part within 01. of Dwg D3208

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 11:12:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL MOUNT ANGLE

Job Number: 28923

Part Number: D32083

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

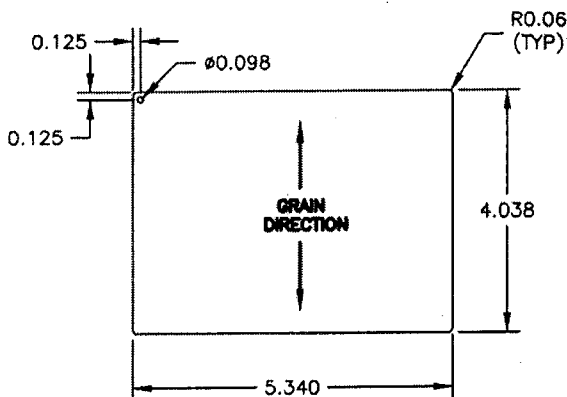
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

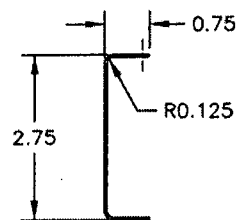


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AI	04.05.25	CHANGE DIM; NOTE 3) CHANGE	

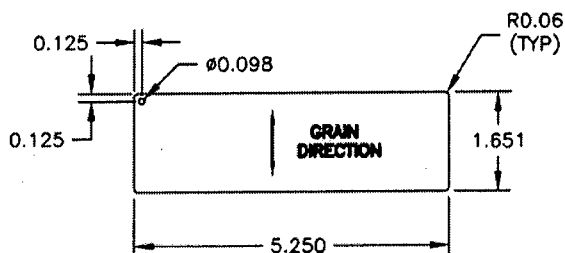
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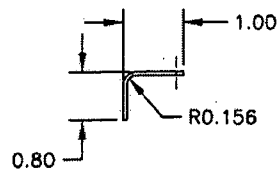
2 D3208-1 DOUBLER
FLAT PATTERN



D3208-1 DOUBLER
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 3) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063" THICK (M6061T6S.063)



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NO. 28923

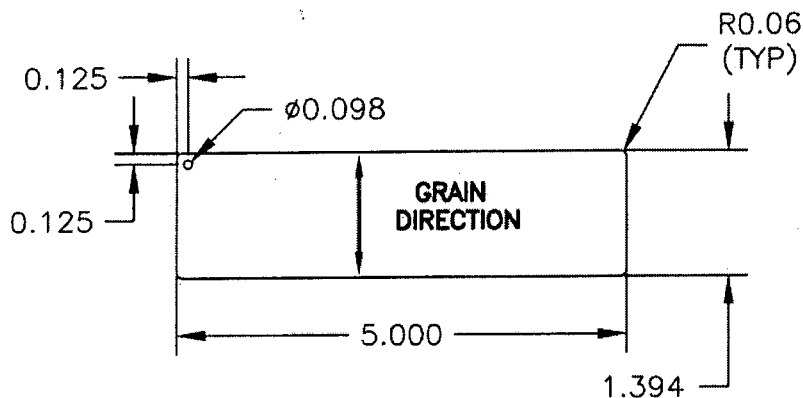
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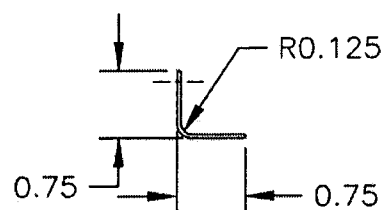
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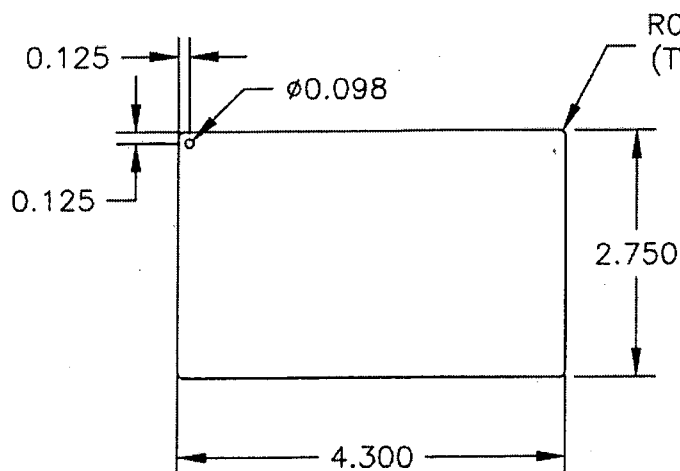


2

**D3208-5 MOUNT ANGLE
FLAT PATTERN**

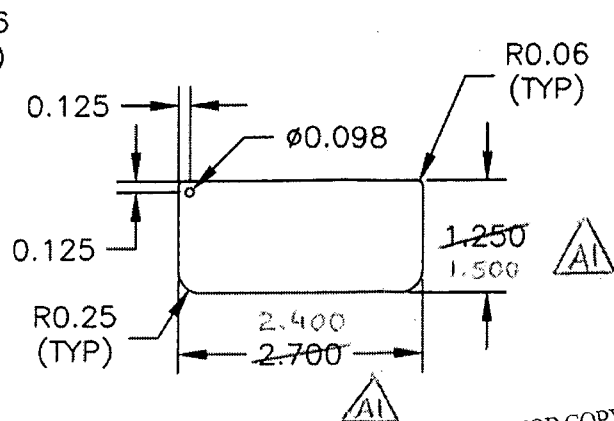


**D3208-5 MOUNT ANGLE
BEND DETAIL**



2

D3208-7 FILLER



2

D3208-11 FILLER

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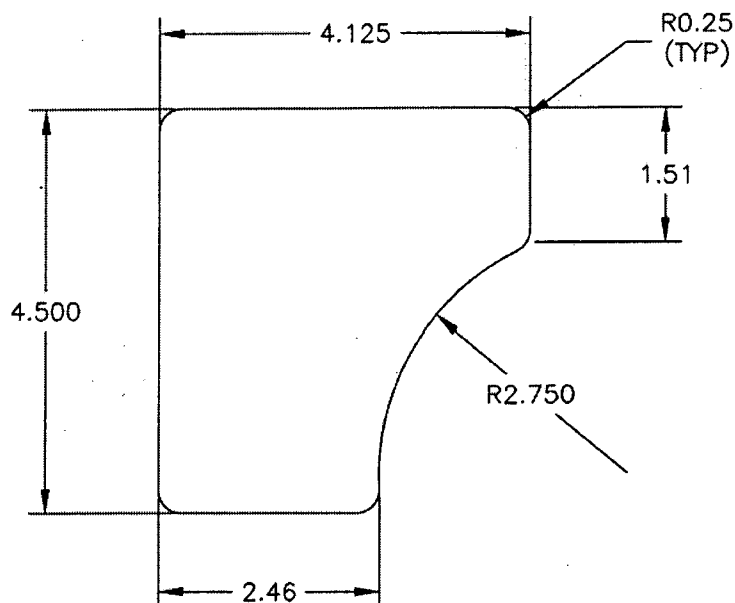
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D3208-9 DOUBLER

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